

Work Order ID 116367

Monday, April 14, 2014 9:27:58 AM

116367

Page 1

Item ID: D350-588-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Assembly

Start Date: 4/14/2014 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/2/2014 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: C2 Date: 14/04/14 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr | | | | | | | | |
|----------------|--------------|--|--|--|--|--|--|--|--|
| D2445/D350-588 | Rev D/D | | | | | | | | |

| | | | | | | | | | |
|-------------------------------|--|------|--|--|--|--|--|--|--|
| 100 | Document Control | 0.00 | | | | | | | |
| *100* | DOCUMENT CONTROL | | | | | | | | |
| DC | Memo | 0.00 | | | | | | | |
| Doc.Control -USB or Paperwork | Photocopy bluefile and create labels per PPP D350-588-041 CHG003 | | | | | | | | |

| | | | | | | | | | |
|------------|--|------|--|--|--|--|--|--|--|
| 110 | PURCHASING | 0.00 | | | | | | | |
| *110* | Purchasing | | | | | | | | |
| Purchasing | Memo | 0.00 | | | | | | | |
| | Issue P/O: <u>23867</u> | | | | | | | | |
| | Description: D2445 Baggage Door | | | | | | | | |
| | Supplier: Delastek | | | | | | | | |
| | Ship to Delastek (1) D0588-041 label | | | | | | | | |
| | Certification of Conformity and process sheet from Delastek is required. | | | | | | | | |

NOV 20 2014

C2 14/04/15 (1)

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Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 4/14/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/2/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Memo

0.00

Packaging

Ensure Certificate of Conformity & Process Sheet are attached

Per 14/5/8 (1)

130

QC6- Inspect dimensions to drawing

0.00

130

QC

Memo

0.00

Quality Control

Inspect as per Dwg D2445.
Audit process sheet.*DAS 27 9-89 14/5/8*

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

Assemble all of the above parts as per Dwg D350-588

14-05-15 (x1)

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Item ID: D350-588-041

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 4/14/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/2/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 155 | Pick Kit | 0.00 | | | | | | | |
| *155* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 160 | QC4- 100% Inspect kits for completeness | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DAS
06
9-89

MAY 20 2014

DAS
31
9-89

DAS
33
9-89 14-05-20

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Item ID: D350-588-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Assembly

Start Date: 4/14/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/2/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location:

0.00

DAS

170

Packaging

Memo

0.00

06

9-89

MAY 20 2014

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

MLD

14-05-20

Quality Control

MF
14-5-20

Picklist Print

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Work Order ID: 116367

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/2/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS
per DSI9414 DD verified by:EC
10.03.29 verified by:EC

IPP Rev:Q as
IPP Rev:R add pick kit DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|-------------------|----------|
| AN526C1032R7 *AN526C1032R7* Screw | | Purchased | No | | | 155 | Each | 290.0000 | 2 | 2 | | | |
| | DAS 06 9-89 | | | | | | | | ** | | | DAS 33 9-89 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST346 | | 290 | | | | | | | |
| | | | | 128831 | | 8 | | | | | | | |
| | | | | M126175 | | 32 | | | | | | | |
| | | | | M128403 | | 250 | | | | | | | |
| AN526C832R8 *AN526C832R8* Screw | | Purchased | No | | | 155 | Each | 351.0000 | 8 | 8 | | | |
| | DAS 06 9-89 | | | | | | | | ** | | | DAS 33 9-89 | 14-05-20 |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST345 | | 351 | | | | | | | |
| | | | | 125388 | | 14 | | | | | | | |
| | | | | m127817 | | 87 | | | | | | | |
| | | | | m128403 | | 250 | | | | | | | |
| AN526C832R9 *AN526C832R9* Screw | | Purchased | No | | | 140 | Each | 668.0000 | 8 | 8 | | | |
| | | | | | | | | | ** | | | | 14-05-19 |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST345 | | 668 | | | | | | | |
| | | | | M127363 | | 4 | | | | | | | |
| | | | | M128403 | | 64 | | | | | | | |
| | | | | M128429 | | 600 | | | | | | | |

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/2/2014

Start Qty: 1.00

Required Qty: 1.00

D2143 Manufactured No 140 Each 22.0000 1 1

D2143

Hinge Bracket

**

ET 14-05-15

Location

Loc Qty

Loc Code

ST005

22

100918

12

108818

7

98391

3

D2144 Manufactured No 140 Each 21.0000 1 1

D2144

Hinge Doubler

**

ET 14 05-15

Location

Loc Qty

Loc Code

ST005

21

100467

21

D2150 Manufactured No 155 Each 16.0000 2

D2150

Packer Doubler, Hinge

06

9-89

**

106861

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST005

16

112962

16

D2151 Manufactured No 155 Each 34.0000 2

D2151

Packer Doubler

**

114304

DAS

33

9-89

1405-20

Location

Loc Qty

Loc Code

ST005

34

102125

2

106821

32

DAS

06

9-89

DAS

31

9-89

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Work Order ID: 116367

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/2/2014

Start Qty: 1.00

Required Qty: 1.00

D2153

Manufactured No

155

Each

60.0000

1

D2153
Door Prop

**

DAS
33
9-89

Location

Loc Qty

Loc Code

FG

4

85865

4

ST260

56

100934

5

110755

18

114286

33

DAS
06
9-89

DAS
31
9-89

D2154

Manufactured No

155

Each

11.0000

1

1

D2154
Bracket, Stud

**

DAS
33
9-89

Location

Loc Qty

Loc Code

ST006

11

100839

11

DAS
06
9-89

DAS
31
9-89

D2237

Manufactured No

155

Each

60.0000

2

2

D2237
Striker Plate

**

DAS
33
9-89

Location

Loc Qty

Loc Code

ST007

60

108708

20

112911

40

DAS
03
9-89

DAS
31
9-89

D2445P

Purchased No

110

Each

0.0000

1

1

D2445P
Aft Door Assembly

**

116367

10/17/81

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Work Order ID: 116367

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/2/2014

Start Qty: 1.00

Required Qty: 1.00

D2461

Manufactured No

155 f

674.9700

7.25 8

**

DAS
33
9-89

14-05-20

D2461
Seal(Per Foot)

DAS
06
9-89

14-05-15
SWP M/SB

(D2461-0870) cut (1) at 87.00"
**** per kit****

Location

Loc Qty

Loc Code

ST402

674.97

102517

174.97

114238

500

114238

DAS
31
9-89

D2463

Manufactured No

140 f

341.6337

7.25

**

ET 14-05-15

D2463
1/2" Seal (\$Per Foot)

Location

Loc Qty

Loc Code

ST402

341.633684

110718

341.633684

x 7.25

(D2463-0870) cut (1) at 87.00"
**** per kit****

D2585

Manufactured No

140 Each

65.0000

2

2

**

ET 14-05-15

D2585
Latch Clamp

Location

Loc Qty

Loc Code

ST012

65

108520

1

110344

3

112571

19

112974

14

114114

28

x 2

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Work Order ID: 116367

116367

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/2/2014

Start Qty: 1.00

Required Qty: 1.00

D2586

Manufactured No

140

Each

47.0000

2

2

D2586

Door Latch

114985

**

ET 14-05-15

Location

Loc Qty

Loc Code

FG

13

100607

2

83893

10

95760

1

ST198A

34

108573

24

113641

10

D2589

Manufactured No

155

Each

21.0000

1

1

D2589

Keys, Key Chain

DAS
05
9-89

**

DAS
33
9-89

14-05-20

Location

Loc Qty

Loc Code

ST012

21

58194

21

58194

DAS
31
9-89

D2621

Manufactured No

140

Each

48.0000

2

2

D2621

Latch Plate

**

ET 14-05-15

Location

Loc Qty

Loc Code

FG

2

88616

2

ST013

46

108138

3

115195

43

XZ

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Work Order ID: 116367

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/2/2014

Start Qty: 1.00

Required Qty: 1.00

D2690-17

Manufactured No

155

Each

33.0000

1

D2690-17

Cable

DAS

14-05-20

33
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST016

33

100752

3

108397

5

110028

6

112206

6

114912

12

94470

1

108397

D2857-1

Manufactured No

140

Each

44.0000

1

1

D2857-1

Hinge Bracket

ST 14-05-15

110247

Location

Loc Qty

Loc Code

FG

5

82261

4

91914

1

ST019

39

106185

3

110247

12

113744

24

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Work Order ID: 116367

116367

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/2/2014

Start Qty: 1.00

Required Qty: 1.00

D2857-2

Manufactured No

140

Each

52.0000

1

1

D2857-2

Hinge Bracket

ST 14-05-15

Location

Loc Qty

Loc Code

FG

3

78904

3

ST019

25

100769

1

108401

24

ST024

24

114154

24

D2858-1

Manufactured No

155

Each

46.0000

1

1

D2858-1

Hinge Bracket

DAS
33
9-89

Location

Loc Qty

Loc Code

FG

2

77019

2

ST019

44

100756

8

110032

12

114144

24

D2858-2

Manufactured No

155

Each

44.0000

1

1

D2858-2

Hinge Bracket

DAS
33
9-89
14-05-20

Location

Loc Qty

Loc Code

FG

2

77020

2

ST020

42

105555

18

113735

24

DAS
03
9-89

DAS
31
9-89

105555

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Work Order ID: 116367

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

116367

D350-588-041

Start Date: 4/14/2014

Required Date: 5/2/2014

Start Qty: 1.00

Required Qty: 1.00

FG-778150-550-ROI Purchased

No 155 sf 2,378.000 1

*FG-778150-550-ROI *

7781 9oz Glass 50x125yd

DAS
06
9-89

Location

Loc Qty

Loc Code

CA

2378

M127570

815

M127701

1563

**

DAS
33
9-89

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

Purchased

No 155 Each 7,961.000 12

MS20426AD3-4

RIVET

DAS
06
9-89

Location

Loc Qty

Loc Code

MF4

365

125578

365

ST334

3192

m127432

3192

ST509

4404

125578

4404

**

DAS
33
9-89

MS20470AD4-5

Purchased

No 155 Each 4,029.000 18

MS20470AD4-5

RIVET, UNIVERSAL HEAD

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

7

m126926

7

ST336

4022

m126926

716

m128401

1653

m128813

1653

**

DAS
33
9-89

14-05-20

126926

DAS
31
9-89

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Work Order ID: 116367

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/2/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

140

Each

6,190.000

8

8

MS21042L08

Nut

**

14-05-15

Location

Loc Qty

Loc Code

ST314

3558

123900

58

m128401

1500

m128429

2000

ST508

2533

125445

1135

m127410

1398

ST509

99

m127304

99

X 8

MS21042L08

Purchased

No

155

Each

6,190.000

10

10

MS21042L08

Nut

**

14-05-20

DAS

06

9-89

Location

Loc Qty

Loc Code

ST314

3558

123900

58

m128401

1500

m128429

2000

ST508

2533

125445

1135

m127410

1398

ST509

99

m127304

99

DAS

33

9-89

125445

DAS

33

9-89

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Work Order ID: 116367

116367

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/2/2014

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No 140 Each 8,800.000 2 2

MS21042L3

Nut

ET 14-05-15

Location

Loc Qty

Loc Code

ST314

1845

M127410

804

M127831

41

M128401

1000

X 2

ST506

955

123900

955

ST509

6000

M128754

6000

MS21042L3

Purchased

No

155

Each

8,800.000

4

MS21042L3

Nut

DAS

33

9-89

14-05-20

Location

Loc Qty

Loc Code

ST314

1845

M127410

804

M127831

41

M128401

1000

ST506

955

123900

955

ST509

6000

M128754

6000

128401

DAS

31

9-89

DAS

03

9-89

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Work Order ID: 116367

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/2/2014

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-11

Purchased

No

155

Each

544.0000

2

MS27039-08-11

SCREW

**

DAS
33
9-89

DAS
05
9-89

Location

Loc Qty

Loc Code

ST307

18

123352

18

ST506

526

122441

37

123185

1

123900

88

M128770

400

122441

DAS
31
9-89

MS27039-1-15

Purchased

No

140

Each

1,027.000

2

2

MS27039-1-15

Screw

**

14-05-15

Location

Loc Qty

Loc Code

ST306

427

124326

427

ST506

600

m127916

600

72

NAS1149D0363J

Purchased

No

140

Each

5,383.000

2

2

NAS1149D0363.J

Washer

**

14-05-15

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

5360

m126319

130

m127813

230

m128429

5000

72

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/2/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

155

Each

5,383.000

2

2

NAS1149D0363J

Washer

**

DAS

33

9-89

14-05-20

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

5360

m126319

130

m127813

230

m128429

5000

DAS
06
9-89

128429

NAS1149DN832J

Purchased

No

140

Each

2,506.000

8

8

NAS1149DN832J

Washer

**

128948 + 8

FT 14-05-15

Location

Loc Qty

Loc Code

MF4

912

M127255

912

ST293

1432

M127813

432

M128429

1000

st510

145

124555

145

ST510a

17

M126319

17

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 4/14/2014

Required Date: 5/2/2014

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

155

Each

2,506.000

16

16

NAS1149DN832J

**

128948

DAS

33

1405-20

Washer

9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

| | | |
|---------|------|--|
| MF4 | 912 | |
| M127255 | 912 | |
| ST293 | 1432 | |
| M127813 | 432 | |
| M128429 | 1000 | |
| st510 | 145 | |
| 124555 | 145 | |
| ST510a | 17 | |
| M126319 | 17 | |

DAS

33

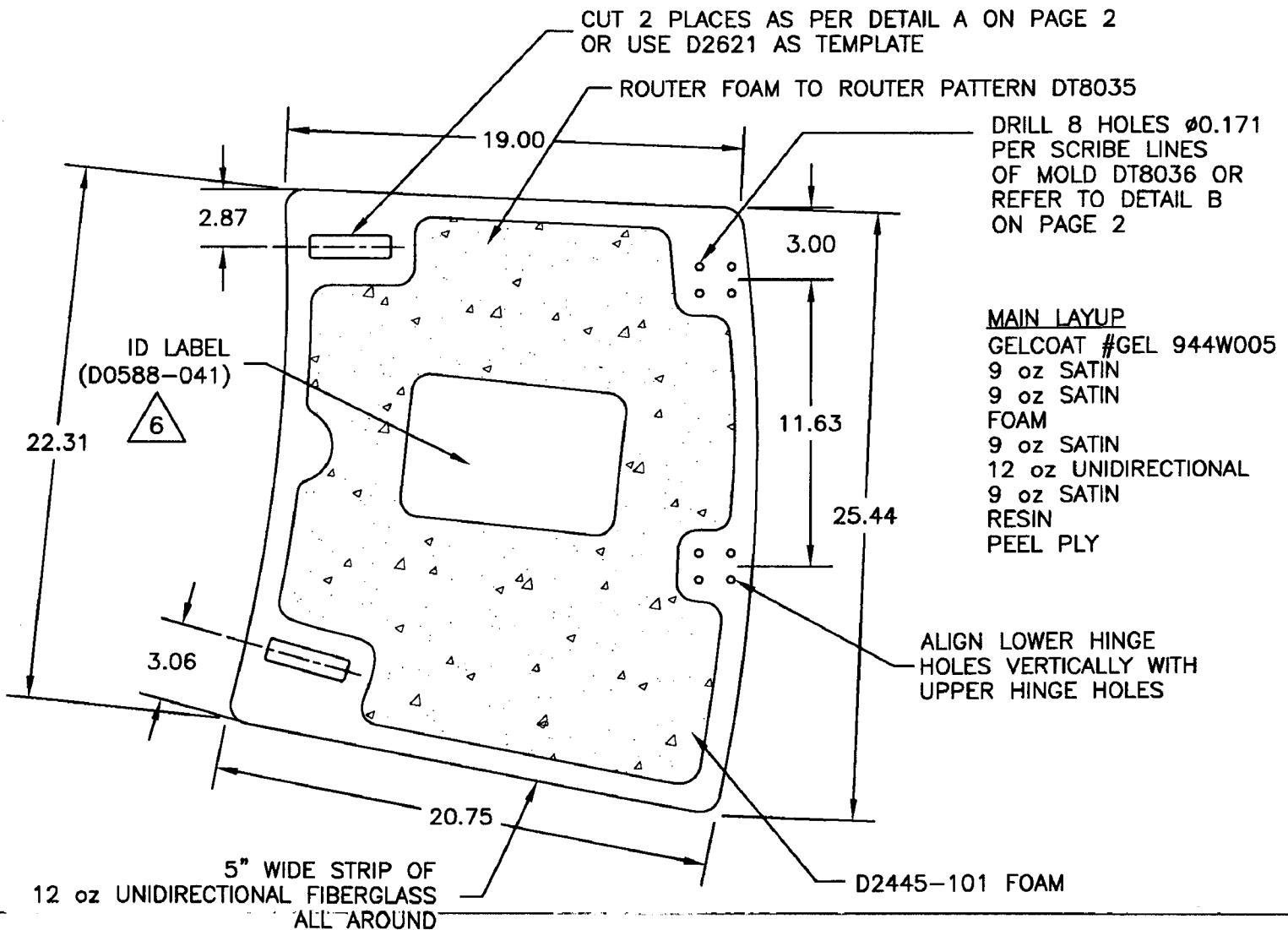
9-89

DART

| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN JB | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2445 | REV. D SHEET 1 OF 2 |
| DATE 06.06.09 | TITLE AFT BAGGAGE DOOR | | SCALE 1:7 |
| A | 97.07.15 | NEW ISSUE | |
| B | 02.01.24 | ADD D2621; D2445-101 | |
| C | 04.02.09 | REMOVE D2621; UPDATE NOTES | |
| D | 06.06.09 | ADD DIMENSIONS TO PERIMETER | |

RELEASED

06.11.13

**NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DMVYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

02/14/04/114
W/O: 116367

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

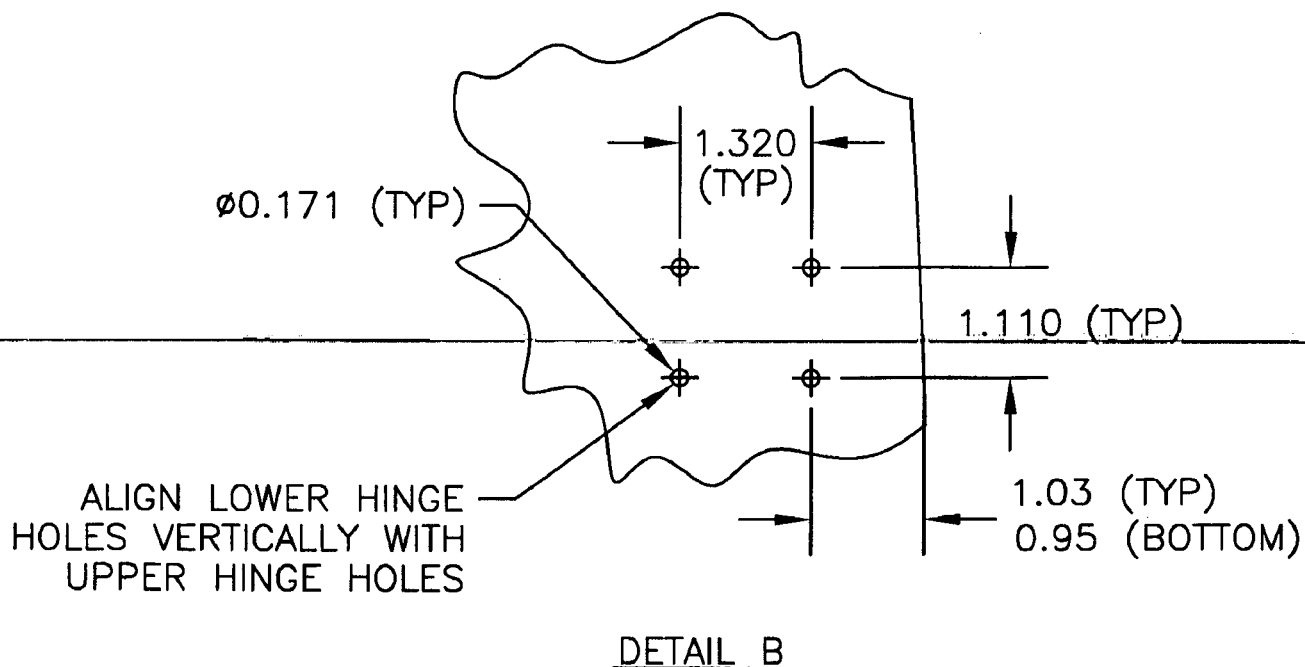
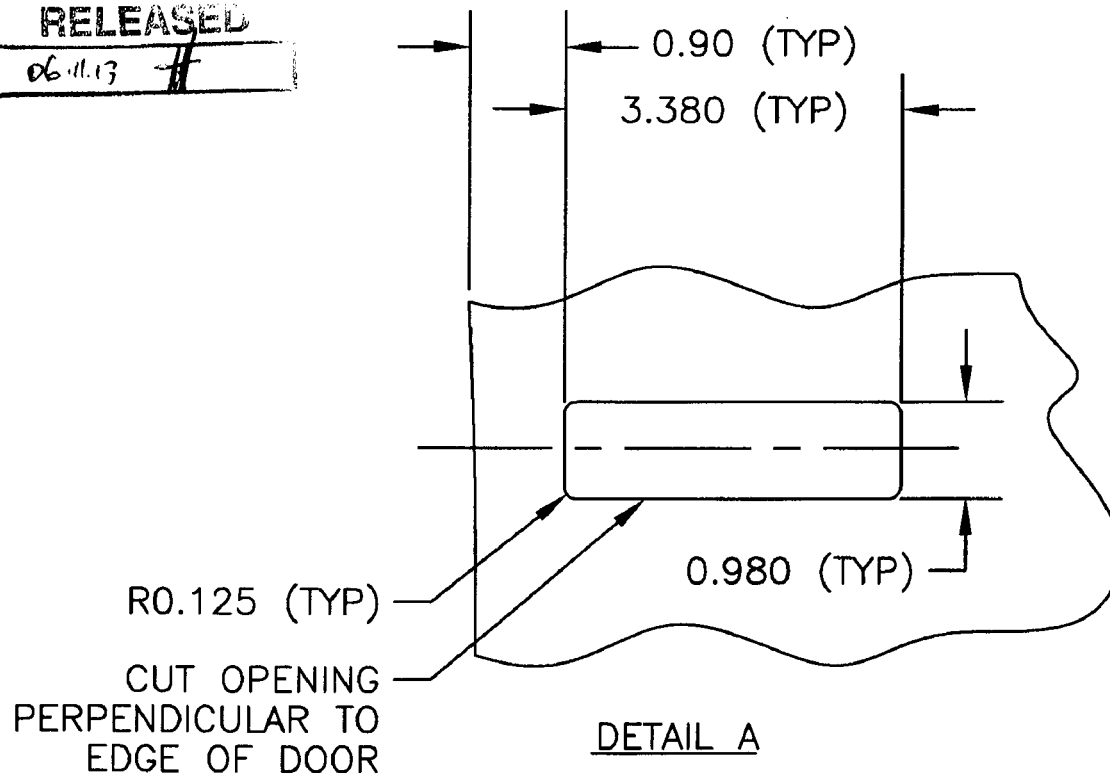
| | | | |
|--|--|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____ |
|--|--|---|---|



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN JB | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2445 | REV. D SHEET 2 OF 2 |
| DATE 06.06.09 | TITLE AFT BAGGAGE DOOR | | SCALE 1:2 |

RELEASED

06.11.13 *[Signature]*



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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

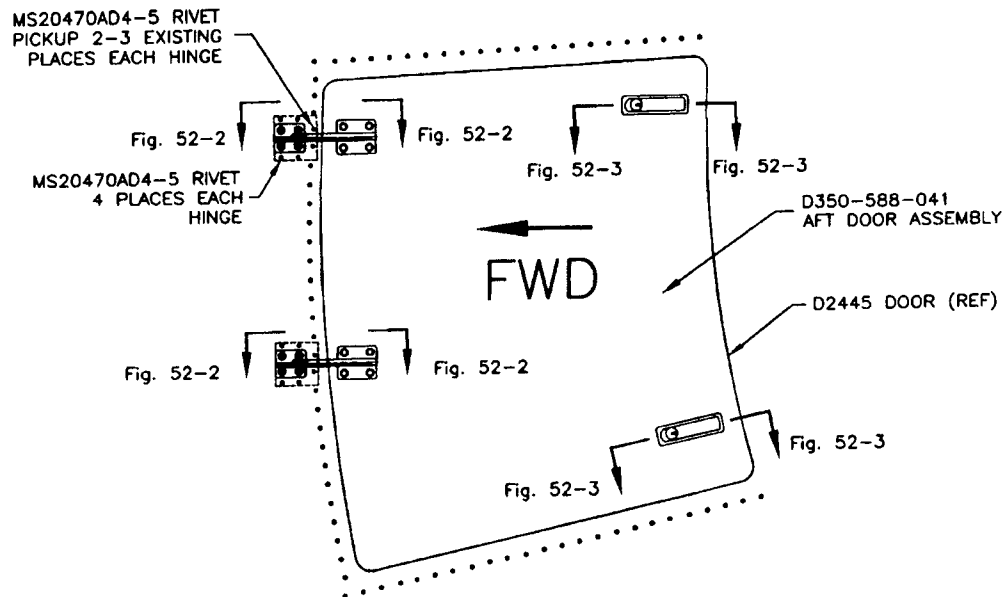


Figure 52-1: Baggage Door Outside View

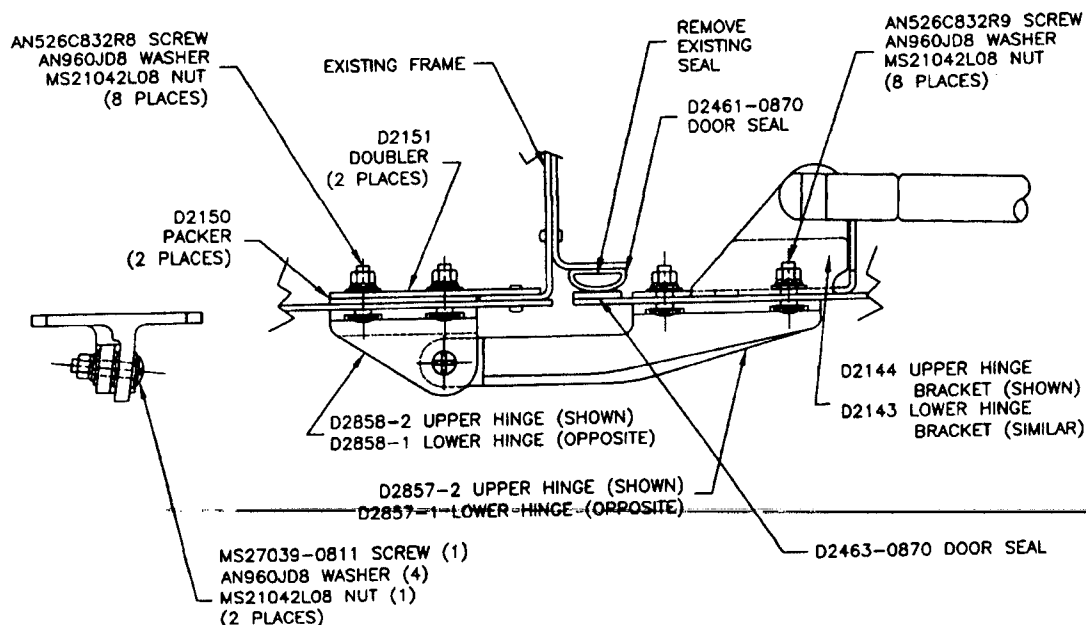


Figure 52-2: Hinge Detail

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52-00-00

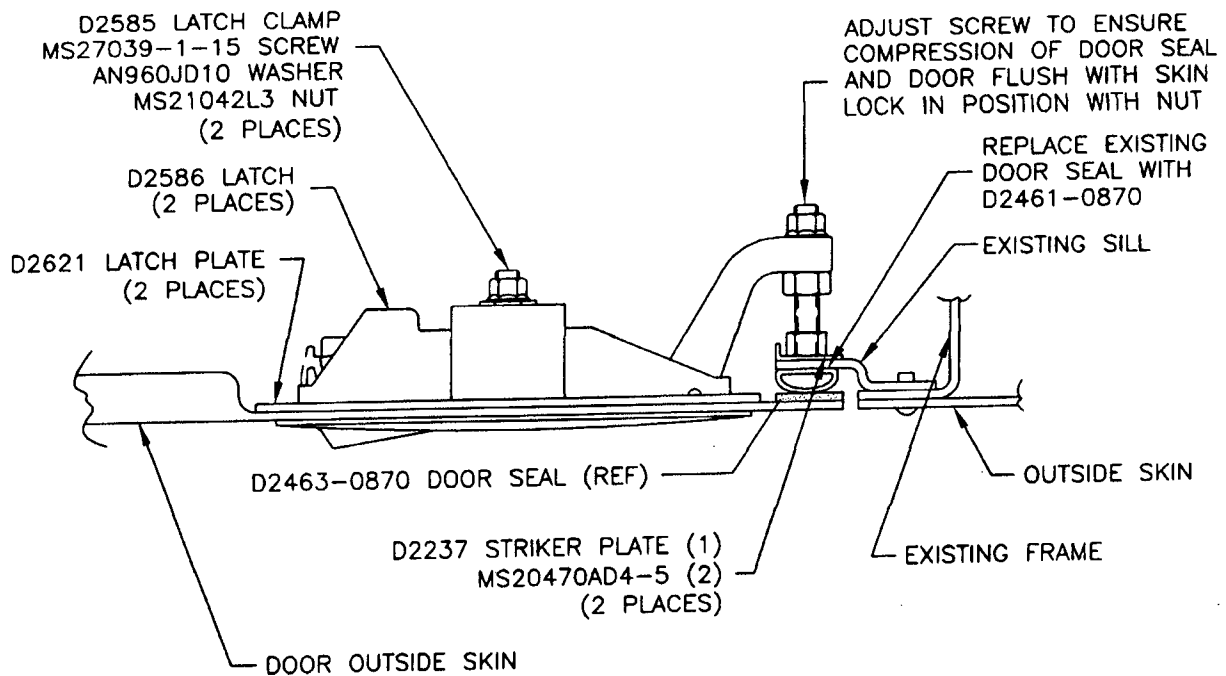


Figure 52-3: Latch Section

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52-00-00

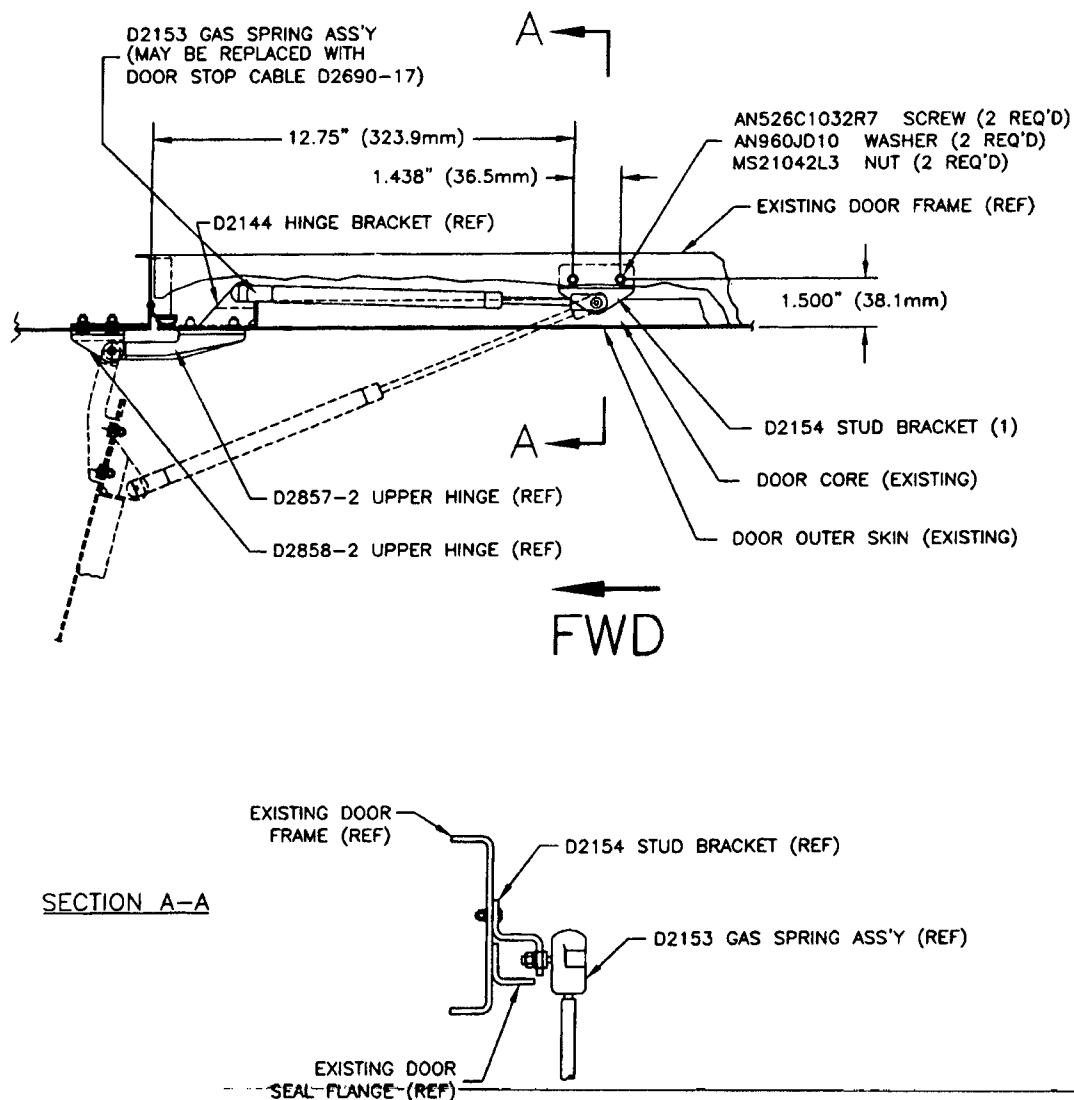


Figure 52-4: Gas Spring Installation

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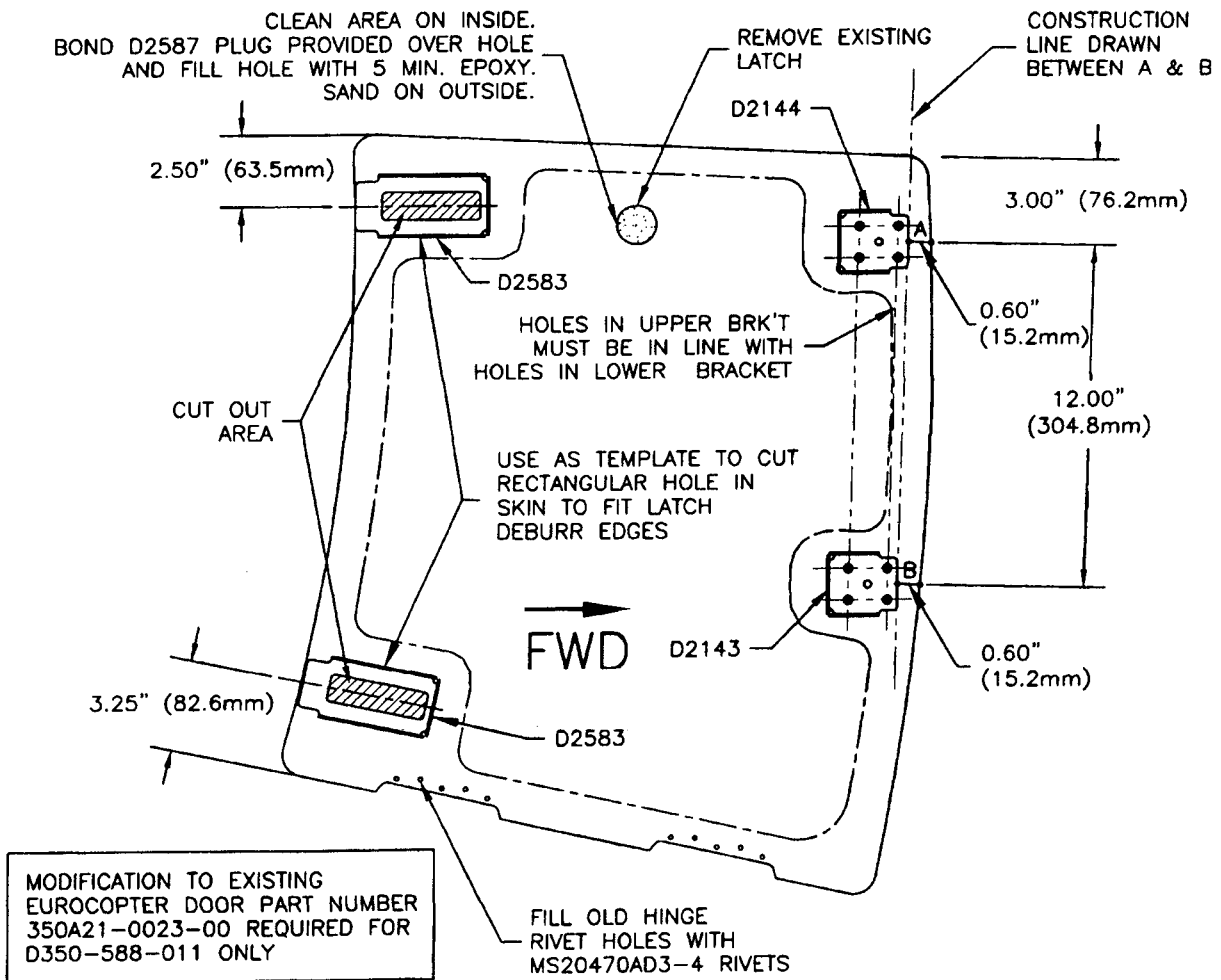
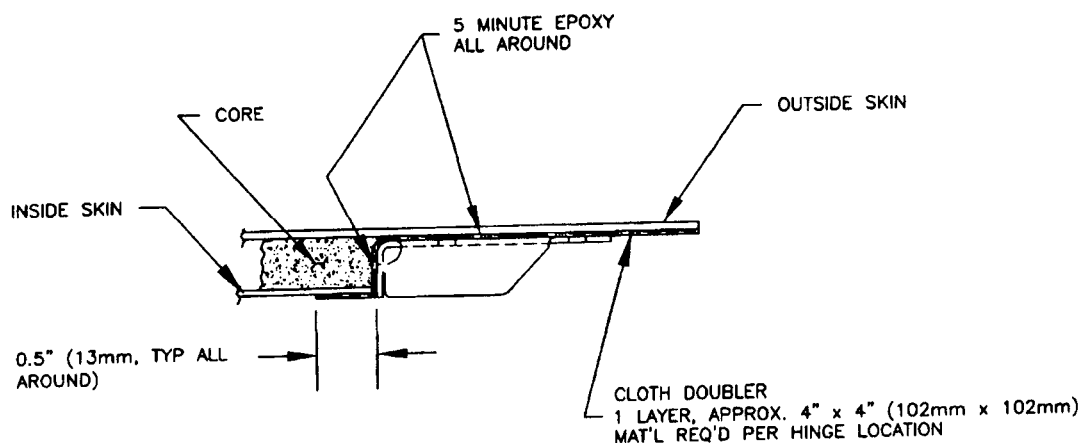


Figure 52-5: Baggage Door Inside View

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52-00-00



SECTION B-B

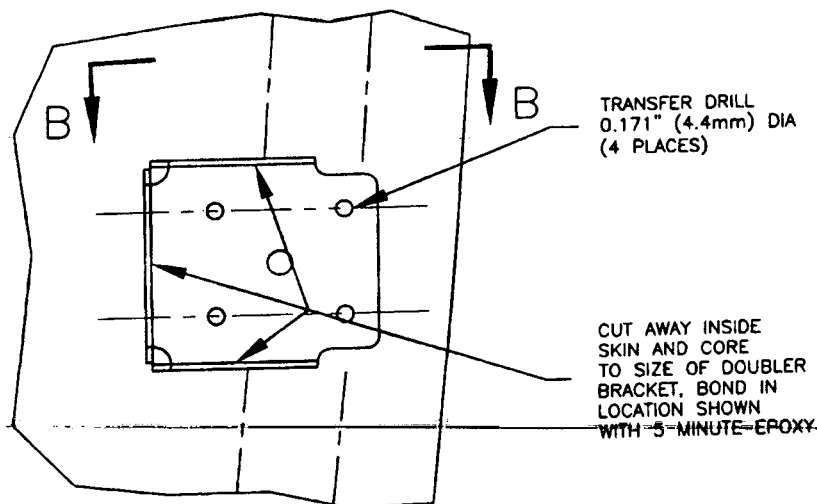


Figure 52-6: Typical Doubler Bracket Installation

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52-00-00



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23807

Purchase Order Date 4/15/2014

PO Print Date 4/15/2014

Page Number 1 of 3

Order From :

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
4/16/14

Contact Name

Vendor Phone

819 533 5788

Ship To Contact

Ship To Phone

Ship Via:

FedEx PI collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

| Line Nbr | Reference Vendor Part Number Line Comments Delivery Comments | Description/ Mfg ID | Req Date/ Taxable Promise Date | CD | Req Qty/ Unit of Measure | PO Unit Price | Extended Price |
|-------------|--|------------------------|--------------------------------------|----|--------------------------------|---------------|----------------|
| 1 | D2445P AS PER DWG D2445 REV. D B116367 | Aft Door Assembly | 5/8/2014 15 Yes 5/8/2014 15 | | 1.00 Each | \$592.76 | \$592.76 |
| Line Total: | | | | | | | \$592.76 |
| 2 | D2445P AS PER DWG D2445 REV. D B116368 | Aft Door Assembly | 5/8/2014 15 Yes 5/8/2014 15 | | 1.00 Each | \$592.76 | \$592.76 |
| Line Total: | | | | | | | \$592.76 |
| 3 | D2445P AS PER DWG D2445 REV. D B116369 | Aft Door Assembly | 5/30/2014 Yes 5/30/2014 | | 1.00 Each | \$592.76 | \$592.76 |

Note:

4/15/2014



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

| | |
|--------------|---------|
| Invoice No. | 57222 |
| Customer No. | DART US |

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

| Ship Date | Order Date | Our SO # | Ordered by | Your PO# | Terms |
|------------------|-----------------|------------------------------|----------------|--|-----------------|
| 07-05-2014 | 15-04-2014 | 24538 | Chantal Lavoie | PO23807 | Net 30 days USA |
| Ship Via | F.O.B. | Salesperson | GST/PST | | |
| FEDEX P1 Collect | Point de départ | Marie-Pier Montambeault, 235 | | | |
| Order Qty | B.O. Qty | Current Ship. | Item number | Description | |
| 1 | 0 | 1 | DKC134-0013 | Line #1 Aft Baggage Door (D2445) B116367 U of M: Chaque Drawing N° : D2445 Rév.: D Serial # Lot # B116367 61086 | |

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Mathieu Ayth
Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mercredi, 2014-04-16 08:13:58
Utilisateur: marc dubé

Feuille de Procédé

1/16 Avril

Client : DART US DART AEROSPACE
Numéro Job : 61086
Numéro : 3959
Numéro B.A. :
Cette fois : 2014-04-16 No. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 55240

Nom Dessin : N° D2445, AFT BAGGAGE DOOR
Numéro Article : DKC134-0013
Numéro Dessin : D2445
Projet Numéro : DK-362
Révision dessin : D
Matériel : Composite
Date Due : 2014-05-15 Qté: 1 Ud UNITE

Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Client: N/A



B116367

E.O.: N/A

Feuille de Procédé Rév.: 05 ajout de l'IF134-0007 sur
plusieurs séquences, numéro du moule passe de
DT-8036 pour DKO-0235, numéro du moule passe de
DT-8619 pour DKO-0063, ajouter IF134-0006 pour le
taillage

Formulaire d'inspection: N/A

Produit additionnel

Numéro Job:



Séq.: Machine ou Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Comment Qty.: 0.200 UNITE(s)/Unit Total : 0.200 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 1-42289-1

2.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DKO-0235 selon IG 0009.

Date: 16/04/14

Seau:



3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Comment Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-45003-2

4.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0320 GALLON(s)/Unit Total : 0.0320 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61086

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

5.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 16/04/14 Sceau:



6.0 GEL COAT Application du Gel Coat



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'application du Gelcoat selon IF134-0007

Date: 16/04/14 Sceau:



7.0 AAC1885 Tissu à délaminer Release ply B

Comment Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)
Tissu à délaminer Release ply B # de Lot: N/A

8.0 AAC1887 Wrightlon 5200 Bleu P3

Comment Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)
Wrightlon 5200 Bleu P3 # de Lot: N/A

9.0 AC0885 Feutre de drainage N° Airweave N 10

Comment Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)

10.0 AC0943 Stretchlon 200 poche à vide Vert

Comment Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

11.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 2.00 VERGE(s)/Unit Total : 2.00 VERGE(s)
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-44353-3

12.0 AMB0511 N° TG-13-U, Fiberglass 13 oz

Comment Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)

N° TG-13-U, Fiberglass 13 oz

N° de Lot: 1-36302-1

13.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Comment Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)

14.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Découper les tissus selon IF134-0007.

Information de référence pour les tissus:

Date: Mercredi, 2014-04-16 08:13:58
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61086

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

4 plis de tissus de 9.7 oz.
1 pli de 13 oz. pour tout le contour de la pièce par 5" de large.
3 fois le sac à vide Strechlon 200.
3 fois le film perforé P-3
3 fois le feutre de drainage
2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Date: 16/04/14

Sceau:



15.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0130 GALLON(s)/Unit Total: 0.0130 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

16.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-45003-1

17.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N°
DDM-9 par quantité de résine N° 411-350.

Date: 16/04/14

Sceau:



18.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Laminer la pièce selon IF134-0007.

Date: 16/04/14

Sceau:



19.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure Curing début: 12:45

Heure Curing Fin: 8:00

Date: 16/04/14

Sceau:



Date: Mercredi, 2014-04-16 08:13:58
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61086

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description:

20.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0042 GALLON(s)/Unit Total: 0.0042 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 127829-1

21.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.120 KILOGRAMME(s)/Unit Total: 0.120 KILOGRAMME(s) RL
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 145003-1

22.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core selon IG0105.

Date: 1 Sceau:



23.0 AAC1611 Polybond B46F

Comment Qty.: 0.045 KIT(s)/Unit Total: 0.045 KIT(s)
Polybond B46F N° de Lot: 1-38189-1

24.0 DKC134-0029 Foam Core N° D2445-101 (Pour AFT Baggage Door)

Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Foam Core N° D2445-101 (Pour AFT Baggage Door) N° de Job: 61091

25.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Coller le Foamcore selon IF134-0007.

Date: 17/04/14 Sceau:



26.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la poche à vide selon IG 0012

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 11:00

Heure fin Curing: 12:20

Date: 17/04/14 sceau:



Date: Mercredi, 2014-04-16 08:13:58
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61086

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

27.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.1360 GALLON(s)/Unit Total: 0.1360 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

28.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-45003-1

29.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst
N° DDM-9 par quantité de résine N° 411-350

Date: 18/04/14 Sceau:



30.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage des tissus de verre selon IF134-0007.

Date: 18/04/14 Sceau:



31.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Heure Curing Début: 8:15 Heure Curing Fin: 8:00

Date: 18/04/14 Sceau:



32.0 DÉMOULAGE Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Démouler la pièce en faisant bien attention aux coins & rebords.

Date: 22/04/14 Sceau:



Date: Mercredi, 2014-04-16 08:13:58

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 61086

Numéro DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

33.0

TRIMAGE

Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Tailler la pièce selon IF134-0006.

Date: 22/04/14 Sceau:



34.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-45373-1

35.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.

Date: 22/04/14 Sceau:



36.0

AAC1021

Dupont Primer N° 7704S

Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-54556-3

37.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-44895-1

38.0

PRIMER

Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation et l'application du primer batisseur selon I.G. 0008

Date: 24-04-14 Sceau: 6587

de fiche de mélange:



39.0

AAC1492

N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-45373-1

40.0

FINITION

Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.

Date: 24/04/14 Sceau:



Date: Mercredi, 2014-04-16 08:13:58
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61086

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro: DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description:

41.0 AAC1605 Label N° D0588-041

Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Label N° D0588-041 N° de Lot: 1-45570-1

42.0 AAC1609 Surface Veil

Comment Qty.: 0.07 VERGE(s)/Unit Total: 0.07 VERGE(s)
Surface Veil N° de Lot: 1-44693-1

43.0 AAC1220 Résine Mia-Poxy 100

Comment Qty.: 0.007 GALLON(s)/Unit Total: 0.007 GALLON(s)
Résine Mia-Poxy 100 N° de Lot: 1-30093-4

44.0 AAC1221 Durcisseur 95 Pour Résine Mia-Poxy

Comment Qty.: 0.007 QUART(s)/Unit Total: 0.007 QUART(s)
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: 1-34505-1

45.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Coller le label N° D0588-041 selon IG 0111

Date: 24/04/14 Sceau:



46.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.0280 UNITE(s)/Unit Total: 0.0280 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-54556-3

47.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-44895-1

48.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation et l'application du primer final selon I.G. 0008

Date: 01/05/14 Sceau:



de fiche de mélange: 6591

49.0 INSPEC FINAL Inspection finale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire l'inspection selon le dessin N° D2445.

Date: 05/05/14 Sceau:



Date: Mercredi, 2014-04-16 08:13:58
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61086

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro: DKC134-0013

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

50.0

EMBAL / ENTREPO

Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage des pièces selon IG 0057

Date: 5/5/14

Sceau:



MAY 20 2014

DART AEROSPACE LTD.

REFERENCE ONLY

D350-588

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3.3 WEIGHT AND BALANCE

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|-------------------------------------|---------|----------|-------------|--------------|--------------|
| | | Arm | Moment | Arm | Moment |
| D350-588-011 | 1.0 lb | -21.0 in | -21.0 in-lb | +170.0 in | +170.0 in-lb |
| Aft Door Fwd Hinge Modification Kit | 0.45 Kg | -0.53 m | -0.24 m-Kg | +4.32 m | +1.96 m-Kg |
| D350-588-041* | 2.0 lb | -21.0 in | -42.0 in-lb | +170.0 in | +340.0 in-lb |
| Aft Door Assembly | 0.91 Kg | -0.53 m | -0.48 m-Kg | +4.32 m | +3.93 m-Kg |

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

3.4 PARTS LISTS

| 588-041 | 588-011 | Part Number | Description |
|---------|---------|---------------|--|
| X | | D350-588-041 | AFT DOOR ASSEMBLY |
| | X | D350-588-011 | AFT DOOR FWD HINGE MODIFICATION KIT |
| 1 | 1 | D2143 | HINGE DOUBLER |
| 1 | 1 | D2144 | HINGE DOUBLER |
| 2 | 2 | D2150 | HINGE PACKER |
| 2 | 2 | D2151 | HINGE DOUBLER |
| 1 | 1 | D2153-3315-10 | GAS SPRING ASSY. |
| 1 | 1 | D2154 | STUD BRACKET |
| 2 | 2 | D2237 | STRIKER PLATE |
| 1 | | D2445 | DOOR |
| 1 | 1 | D2461-0870 | NEOPRENE D SEAL |
| 1 | 1 | D2469-0870 | 1/2" FOAM SEAL |
| | 2 | D2583 | LATCH BRACKET |
| 2 | 2 | D2585 | LATCH CLAMP |
| 2 | 2 | D2586 | LATCH |
| | 1 | D2587 | PLUG |
| 1 | 1 | D2589 | KEYS, KEY CHAIN |
| 2 | | D2621 | LATCH PLATE |
| 1 | 1 | D2690-17 | CABLE, DOOR STOP |
| 1 | 1 | D2857-1 | LOWER HINGE BRACKET |
| 1 | 1 | D2857-2 | UPPER HINGE BRACKET |
| 1 | 1 | D2858-1 | LOWER HINGE BRACKET |
| 1 | 1 | D2858-2 | UPPER HINGE BRACKET |
| 8 | 8 | AN526C832R8 | SCREW (or AN526-832R8) |
| 8 | 8 | AN526C832R9 | SCREW (or AN526-832R9) |
| 2 | 2 | AN526G1032R7 | SCREW (or AN526-1032R7) |
| 24 | 24 | AN960JD8 | WASHER |
| 4 | 4 | AN960JD10 | WASHER |
| 12 | 12 | MS20426AD3-4 | RIVET |
| 18 | 18 | MS20426AD3-5 | RIVET |
| 18 | 18 | MS21042-08 | NUT (or MS21042-08) |
| 4 | 4 | MS21042-3 | NUT (or MS21042-3) |
| 2 | 2 | MS27039-1-15 | SCREW |
| 2 | 2 | MS27039-08-11 | SCREW |
| 1 | 1 | N/A | 1 SQUARE FT OF 19 OZ GLASS CLOTH (S-CLASS) |

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Revision: D

Date: 02.01.17

3.0 PARTS LIST:

The part lists of D350-588 Rev. D and ICA-D350-588 Rev. D are amended as follows.

IS:

| 588 -041 | 588 -011 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------|---|
| X | | D350-588-041 | AFT DOOR ASSEMBLY |
| | X | D350-588-011 | AFT DOOR FWD HINGE MOD |
| 2 | 2 | D5080-041 | STRIKER PLATE ASSY (AS355 N/NP MODELS ONLY) |
| 2 | 2 | D2237 | STRIKER PLATE |

WAS:

| 588 -041 | 588 -011 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------|------------------------|
| X | | D350-588-041 | AFT DOOR ASSEMBLY |
| | X | D350-588-011 | AFT DOOR FWD HINGE MOD |
| 2 | 2 | D2237 | STRIKER PLATE |

Customers who need to upgrade a D350-588-011/-041 kit that has been previously purchased from Dart can procure the DSI 9690-011 Kit from Dart.

| QTY -011 | PART NUMBER | DESCRIPTION |
|-------------|--------------|--------------------------------|
| X | DSI 9690-011 | STRIKER PLATE MODIFICATION KIT |
| 2 | D5080-041 | STRIKER PLATE ASSEMBLY |

4.0 WEIGHT AND BALANCE:

This DSI has a negligible effect on Weight and Balance of the aircraft.

5.0 MAINTENANCE:




Maintain the D5080-041 Striker Plates in accordance with the procedures for the D2237 Striker Plates as outlined in ICA-D350-588.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH92-41
ISSUE NO.: 8

| | | | |
|------------|---|--|--------------|
| DESIGN | ML | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | ML | | |
| CHECKED |  | DRAWING NO. | REV. A |
| MFG. APPR. | N/A | DSI 9690 | SHEET 2 OF 2 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | STRIKER PLATE MOD | NTS |
| DATE | 14.03.24 | COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT | |

Linda Lacelle

From: Marc Bellavance
Sent: May-20-14 11:43 AM
To: Melanie Fauteux; Linda Lacelle
Subject: RE: D350-588-041 / -011

Go for it, ship it! No AS355N's at AMRG.

From: Melanie Fauteux
Sent: May-20-14 11:29 AM
To: Marc Bellavance; Linda Lacelle
Subject: RE: D350-588-041 / -011

Shipping to Air medical resource...Utah

From: Marc Bellavance
Sent: Tuesday, May 20, 2014 11:24 AM
To: Linda Lacelle
Cc: Melanie Fauteux
Subject: RE: D350-588-041 / -011

Where are we shipping these?
BL (as in Bob Loblaw ☺)

From: Linda Lacelle
Sent: May-20-14 11:22 AM
To: Marc Bellavance
Cc: Melanie Fauteux
Subject: D350-588-041 / -011
Importance: High

The open w/o's were not changed to update the bom to add the D5080's, can we ship without? We have 2 kits to ship today!
LL